

Work Order ID 98750

98750

~~PRELIMINARY ISSUE~~

Page 1

March-22-13 9:18:03 AM

Item ID: D4664-5

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Stop

NS2

Item Name: Spacer

Start Date: 3/22/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/25/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4664

A U/R

Rev B

0.00

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-Turn as per Folio and dwg

Folio Rev: N/A

Dwg Rev: MS PB2

-Deburr

0.00

PD 13/03/23

12

Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

PD 13/03/23

12

Ø

Work Order ID 98750

98750

Page 2

March-22-13 9:18:03 AM

Item ID: D4664-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: U/R Stop *NS2*
 Item Name: Spacer
 Start Date: 3/22/13 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 3/25/13 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

122 Chemical Conv. Coat

123 QCT. Inspect Chemical Conv.

SMO

13325

12
 Inspected on 13/4/10
 Due 13/2

POSITIVE RECALL

EFFECTIVE 130322 AUTHU
 DATED 8 DATE 13/4/10
 Pursuits to Rev B.

13-04-10

Picklist Print

March-22-13 9:18:03 AM

Page 1

Work Order ID: 98750

Parent Item: D4664-5

Parent Item Name: Spacer

Start Date: 3/22/13

Required Date: 3/25/13

Start Qty: 12.00

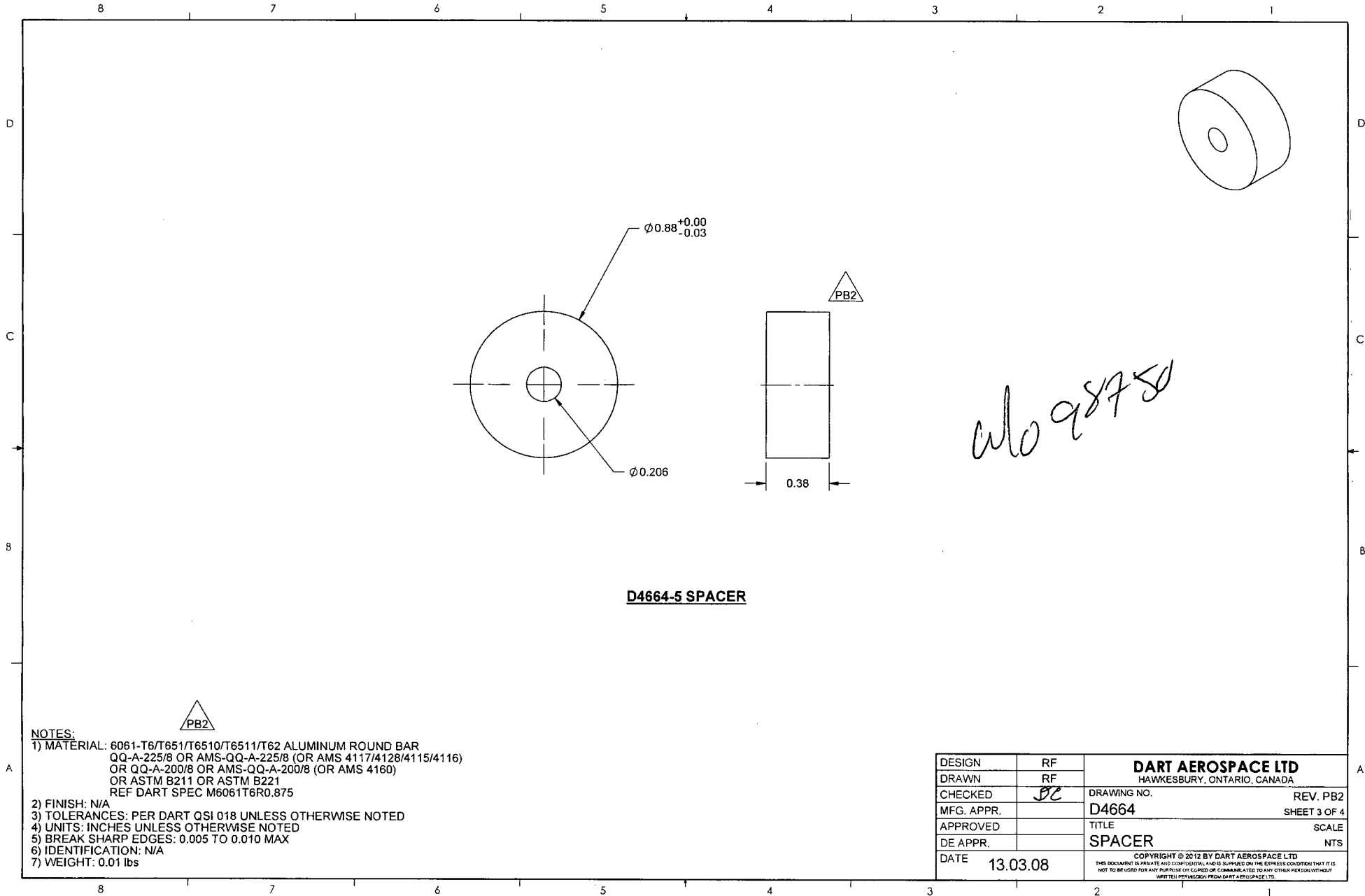
Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 12-11-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 ROUND BAR 1.00"		Purchased	No				f	53.8430		0.384		PO 13/03/123	

Location	Loc Qty	Loc Code
MAT012	11.542	
121070	11.542	
MAT013	42.301	
116406	6.703	
118271	11.4	
121192	9.64	
122521	8.855	
123483	5.703	

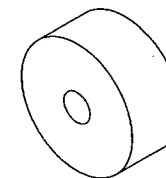
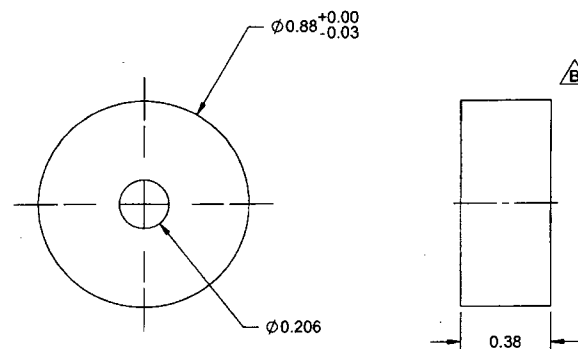
~~5.52~~ .443



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6R0.875
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>SC</i>	DRAWING NO.	REV. PB2
MFG. APPR.		D4664	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	13.03.08	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4664-5 SPACER

RELEASED
2013-04-02
AND

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R0.875
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	ST	D4664	SHEET 3 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	SPACER	NTS
DATE	13.03.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	